

Date: Wednesday, 10/10/2007 11:00:03 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : RH STEP ACTUATOR ASSEMBLY
Job Number : 35060	
Estimate Number : 12760	
P.O. Number : <i>NA</i>	Part Number : 41232 000 001 002
This Issue : 10/10/2007 S.O. No. : <i>NA</i>	Drawing Number : 41232-000-001 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>NA</i> Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 31568	Material : <i>NIA</i>
Written By : <i>[Signature]</i>	Due Date : 10/30/2007 Qty: 1 Um: Each
Checked & Approved By : <i>[Signature] 07 10 10</i>	
Comment : Est Rev: A New Issue 07-02-28 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP41232-000-001

CHG 001 002


07.10.17 [Signature]

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	AP0925ELBN	BARBED ELBOW
-----	------------	--------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

BARBED ELBOW

Batch: *M103727*
[Signature]


4.0	AN960JD416	Washer
-----	------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

Batch: *M104746*
[Signature]


5.0	MS21042L4	Nut
-----	-----------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Nut

Batch: *M104683*
[Signature]

[Signature] 07/10/16 0

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/10/2007 11:00:03 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RH STEP ACTUATOR ASSEMBLY

Job Number: 35060

Part Number: 41232 000 001 002

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN423A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M103688 -

7.0

MS3548993

GROMMET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GROMMET

Batch: M105792 -

8.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M105408 -

9.0

MS24665151

Cotter Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cotter Pin

Batch: M14526 -

10.0

MS203923C21

Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pin

Batch: M104156 -

11.0

R 3400

plastic tubing 1/4id x 3/8od-black



Comment: Qty.: 3.0500 f(s)/Unit Total : 3.0500 f(s)

plastic tubing 1/4id x 3/8od-black

Cut to 18" Long X2

Batch: M104229 -

12.0

41232 200 006 001

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

Batch: 330505 -

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/10/2007 11:00:03 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RH STEP ACTUATOR ASSEMBLY

Job Number: 35060

Part Number: 41232 000 001 002

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

41232 200 005 001

Spacer (Step Actuator)



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)
Spacer (Step Actuator)
Batch: B30503 -

14.0

41232 200 004 001

Reducer Tee Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Reducer Tee Assembly
Batch: B31779 -

15.0

41232 200 003 001

Spring (Step Actuator)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Spring (Step Actuator)
Batch: B30941 -

16.0

41232 200 001 002

Step Actuator RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Step Actuator RH
Batch: B35182

41232 200 001 002 2008/1/17

17.0

124K002 4CR 0545

Hose ass'y-Step Actuator



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Hose ass'y-Step Actuator
BATCH: 1104384 -

18.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP 41232-000-001-001

Location: B

PPP Rev: 8/1/17

SD (X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 28/01/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/10/2007 11:00:03 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RH STEP ACTUATOR ASSEMBLY

Job Number: 35060

Part Number: 41232 000 001 002

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

D 08/01/18

Job Completion



2008.1.17
W

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REVISION					
LETTER	DFTSMAN	DATE	DESCRIPTION	APPROVED	DATE
A	DNN	1/14/04	INCP. E.O.; CHG. P/N OF ITEM #17.	1/14/04	1/14/04
MINOR CHANGE - FAR 21.95					

A			1	1	17	PS4025E000DF540A	HOSE						
			1	1	16	AP0925ELBN	BARBED ELBOW	ARK-PLAS PRODUCTS, INC., FLIPPIN, ARKANSAS 72634					
			2	2	15	AN960JD416	WASHER						
			1	1	14	MS21042-L4	NUT						
			1	1	13	AN4-23A	BOLT						
	AR	AR	12			MIL-S-8802	SEALANT						
			1	1	11	MS35489-93	GROMMET						
			2	2	10	AN960JD416L	WASHER						
			1	1	9	MS24665-151	COTTER PIN						
			1	1	8	MS20392-3C21	PIN						
			2	2	7	R-3400 1/4 ID x 3/8 OD BLACK	PLASTIC TUBING	NORTON PERFORMANCE PLASTICS CORP., AKRON, OHIO 44309					
			1	1	6	41232-200-006-001	BRACKET	(ALT. P/N 412-050-026-101, BELL HELICOPTER)					
			3	3	5	41232-200-005-001	SPACER						
			1	1	4	41232-200-004-001	REDUCER TEE						
			1	1	3	41232-200-003-001	SPRING						
			1		2	41232-200-001-002	R/H ACTUATOR ASSY						
			1		1	41232-200-001-001	L/H ACTUATOR ASSY						
						-002	R/H INSTALLATION						
						-001	L/H INSTALLATION						
			-002	-001	FIND NO.	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL SPEC	ZONE		
NO. REQ'D PER ASSY													
LIST OF MATERIAL													
PROPRIETARY RIGHTS NOTICE THESE DATA ARE PROPRIETARY TO ERA AIRCRAFT, INC. NO DISCLOSURE, REPRODUCTION, OR USE OF THESE DATA FOR ANY PURPOSE IS FORBIDDEN WITHOUT WRITTEN AUTHORIZATION FROM ERA AIRCRAFT, INC. THE FOREGOING DOES NOT APPLY TO VENDOR PARTS.													
UNLESS OTHERWISE SPECIFIED X.X.1 XXX.X.03 XXX.X.010 ANGLES ±.1/2"													
DFTSMAN D. NELSON 5/20/02 CHECK D. MURPHY 5/20/02 STRESS PREL. ENGR. HEAT TREAT FINISH													
TITLE STEP ACTUATOR INSTALLATION DWG. SIZE C SCALE NONE ERA AIRCRAFT, INC. DWG. NO. 41232-000-001 SHT 1 OF 2 REV. A													
41232-1000 NEXT ASSEMBLY DNN													

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 35060

